

Work Order ID 95616

Tuesday, January 15, 2013 2:54:28 PM

95616

Page 1

Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206L/407)
 Start Date: 1/15/2013 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 2/15/2013 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: 13-01-15 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	D

100	Skidtubes	0.00
100		
Skidtubes	Memo	0.00
Skidtubes	1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018 3- Deburr	

10 CF13-227

110	HAAS CNC VERTICAL MACHINING #1	0.00
110		
HAAS 1	Memo	0.00
HAAS CNC vertical machine #1	1-Machine as per Folio FA579 & Dwg D3282 2-Deburr	

13/03/02
13/03/01

10

120	QC2- Inspect parts off machine FAI/FAIB	0.00
120		
QC	Memo	0.00
Quality Control		

13/03/02

10

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		FB 13/03/04		10	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	0	CF 13-3-6	
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							



10 DP 13-3-6

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Skidtubes*

Skidtubes

Memo

0.00

Skidtubes

1-Install doublers as per Dwg D3282.

10 CF 13-3-7
P10 →

170

0.00

170

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

DAS
16
13/3/7

NO

180

0.00

180Identify as per dwg & Stock Location: LG

Packaging

Memo

0.00

Packaging

10 CF 13-3-7

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Q/12Date: 12/03/11QA Closed: CFDate: 13/3/8

Work Order: <u>95616</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>D3283-1</u>				Rework <input type="checkbox"/>		Skid-tube <input checked="" type="checkbox"/>		Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>	
NCR No. <u>137385</u>				Scrap <input checked="" type="checkbox"/>		Machining <input type="checkbox"/>		Small Fab <input type="checkbox"/>		Prod. Eng. Coord. <input type="checkbox"/>		Quality <input type="checkbox"/>	
				Use-as-is <input type="checkbox"/>		Thermoforming <input type="checkbox"/>		Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>	
				Work Order Update <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data				Found when install in web that D3283-1 Doubler had a spot next to a hole that had a drill point mark RC missed at inspection on w/093814	DAS 16 9-8 052042 13/3/7	REAR of CAUSE to CRACK D3283-1 was SCRAPED- Replace D3283-1 Qty of 3 93814	CF 13-3-1	DAS 16 9-8 13/3/7	DAS 16 9-8 052042 13/3/7
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear		General		Grain		Ovalized		Pressure/Forced	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Weld	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Misread	<input type="checkbox"/> Offset	<input type="checkbox"/> Burrs	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions	
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Contamination	<input type="checkbox"/> Misread	<input type="checkbox"/> Offset	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions		
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Offset	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Outside Dimensions			
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Outside Dimensions			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Outside Dimensions			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Outside Dimensions			
	<input type="checkbox"/> Finish	<input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Outside Dimensions			
	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Outside Dimensions			

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MCS 13-03-07

13-03-07

Picklist Print

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Work Order ID: 95616

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Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 1/15/2013

Required Date: 2/15/2013

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM
remove LPS as per dwg revD DD verf:JLM

IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2792-130		Manufactured	No			100	Each	80.0000	1	10			
D2792-130									**	10		CF 13-2-27	
EXTRUSION													

Location	Loc Qty	Loc Code
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LG	80	
91989	80	

D3283-1		Manufactured	No			160	Each	47.0000	2	20			
D3283-1									**			CF 13-3-7	
Doubler													

Location	Loc Qty	Loc Code
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LG	29	
93814	29	
ST178	18	
92179	18	

MS20470AD4-7		Purchased	No			160	Each	9,033.000	57	570			
MS20470AD4-7									**			CF 13-3-7	
Rivet, Universal Head													

Location	Loc Qty	Loc Code
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ST336	4989	
122452	103	
123525	4886	
ST509	4044	
124231	4044	

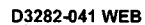
DART AEROSPACE LTD		Work Order:	95616
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.60	—		M-tape	ML-08
1.500	+/-0.010	1.500	—		Vern	ML-06
3.000	+/-0.010	3.000	—		"	"
6.000	+/-0.010	6.000	—		"	"
1.250	+/-0.010	1.250	—		"	"
30.000	+/-0.010	30.000	—		M-tape	ML-08
1.500	+/-0.010	1.500	—		Vern	ML-06
72.01	+/-0.030	72.010	—		M-tape	ML-08
61.75	+/-0.030	61.750	—		"	"
57.50	+/-0.030	57.500	—		"	"
49.19	+/-0.030	49.190	—		"	"
43.94	+/-0.030	43.940	—		"	"
39.69	+/-0.030	39.690	—		"	"
26.68	+/-0.030	26.680	—		"	"
0.55	+/-0.030	.550	—		Vern	ML-06
1.970	+/-0.010	1.963	—		"	"
2.38	+/-0.030	2.372	—		"	"
0.05	+/-0.030	.055	—		"	"

Measured by: <i>ML</i>	Audited by: <i>F.K.</i>	Preliminary Approval:
Date: 13/02/02	Date: 13/03/04	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	<i>[Signature]</i>



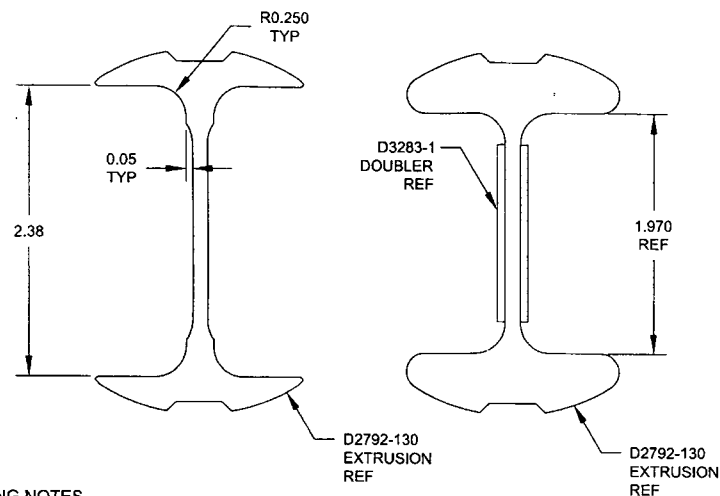
RELEASED
2011-09-12

- | | | | |
|------------|---|--|--------------|
| D | ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1) | SC | 11.05.05 |
| C | REMOVE D3390-1, NOW MACHINED | CP | 05.08.09 |
| B | MOVE HOLES, ADD D3390-1 DOUBLERS | CP | 05.03.16 |
| A | NEW ISSUE | CP | 04.05.05 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | CP | DART AEROSPACE USA, INC
PORT HADLOCK, WA | |
| DRAWN | SC | | |
| CHECKED | <i>qf</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>BE</i> | D3282 | SHEET 1 OF 2 |
| APPROVED | <i>AP</i> | TITLE | SCALE |
| DE APPR. | <i>II</i> | WEB | NTS |
| DATE | 11.05.05 | COPYRIGHT © 2004 BY DART AEROSPACE USA, INC
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8 7 6 5 4 3 2 1

SECTION A-A

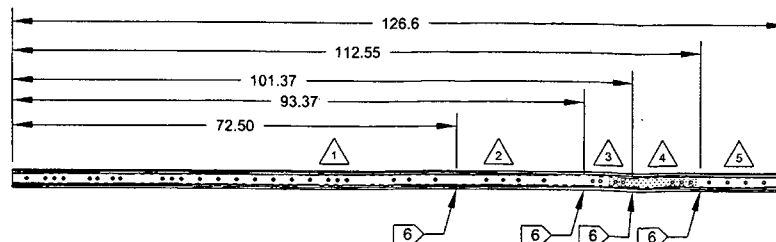
SECTION B-B



95616

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3282	SHEET 2 OF 2
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
		WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1